

November-14-11 8:08:37 AM

76408

Page 1

N900040100

Setup Start ***NS1***

Stop ***NS2***

10

10

Reference:

Run Start *NR1*

Stop ***NR2***

Draw Nbr	Revision Nbr
DSK081	Rev A

0.00

MORI SEIKI CNC LATHE LARGE

Memo

Turn blank as per Folio FA079

0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

QC8- Inspect parts - second check

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76408

76408

Page 2

November-14-11 8:08:37 AM

Item ID: DSK081 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: D2940-1 TURNING DETAIL
 Start Date: 14/11/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 28/11/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: <u>CWC</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten notes:
 20 11. 11. 24 10 4
 11/11/24
 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-14-11 8:08:42 AM

Page 1

Work Order ID: 76408

76408

Parent Item: DSK081

DSK081

Parent Item Name: D2940-1 TURNING DETAIL

Start Date: 14/11/2011

Required Date: 28/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6104-007

Manufactured

No

Each

14.0000

10

D6104-007

**

SA 11/11/22

Round Billet, 17-4

Location

Loc Qty

Loc Code

MAT043

12

73504

12

MAT046

2

71182

2

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries


DART AEROSPACE LTD		Work Order:	
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET



☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.962	4.958	4.958	4.958	4.958
C	0.718	0.738		.726	.726	.726	.726	.726
D	0.090	0.110		.102	.102	.102	.102	.102
E	3.564	3.584		3.574	3.574	3.574	3.574	3.574
F	0.022	0.042		.031	.031	.031	.031	.031
G	3.444	3.464		3.454	3.454	3.454	3.454	3.454
H	0.112	0.132		.117	.117	.117	.117	.117
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.461	4.461	4.461	4.461	4.461
K	0.413	0.433		.430	.426	.426	.426	.426
L	0.913	0.933		.927	.925	.925	.925	.925
M								
N								
O								
P								

Measured by:  **Date:** 11/11/23

Audited by:  **Date:** 11-11-24

Prototype Approval:  **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

DART AEROSPACE LTD		Work Order:	
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

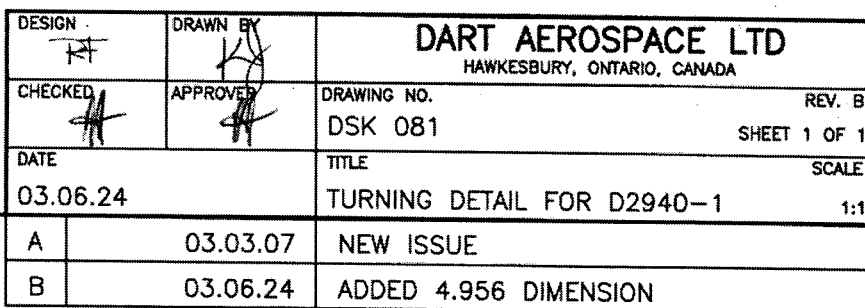
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.958	4.958	4.958	4.958	4.958
C	0.718	0.738		.726	.726	.726	.726	.726
D	0.090	0.110		-.102	-.102	-.102	-.102	-.102
E	3.564	3.584		3.574	3.574	3.574	3.573	3.573
F	0.022	0.042		-.031	-.031	-.031	-.031	-.031
G	3.444	3.464		3.453	3.453	3.454	3.453	3.453
H	0.112	0.132		-.119	-.120	-.119	-.120	-.120
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.460	4.461	4.462	4.461	4.461
K	0.413	0.433		.426	.426	.426	.426	.426
L	0.913	0.933		.925	.925	.925	.925	.925
M								
N								
O								
P								

Measured by: SA Date: 11/11/22

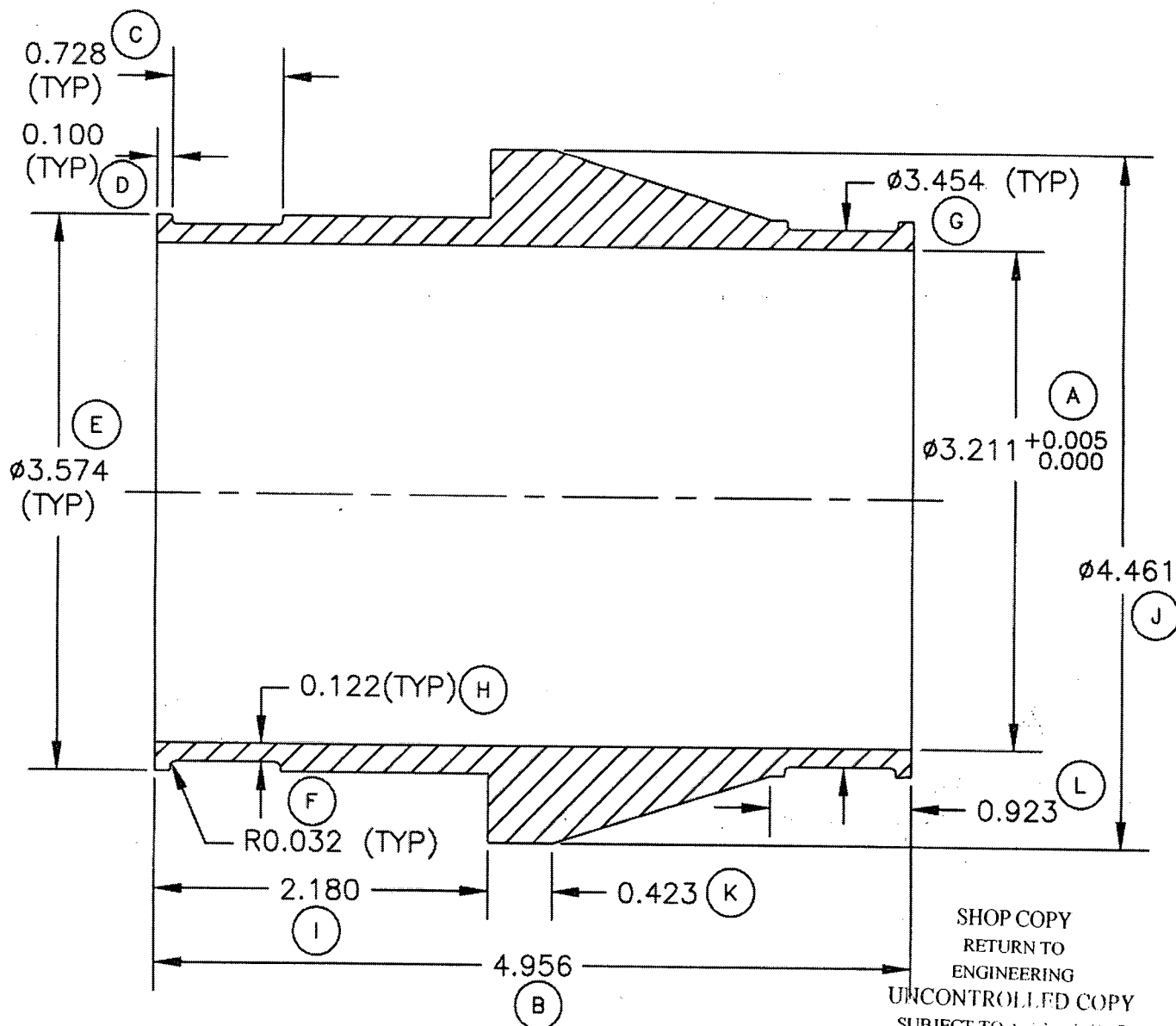
Audited by: RA Date: 11.11.24

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>[Signature]</u>



RELEASED
03-07-01



D2940-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76408 MC5
11/11/14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries